

Work Order ID 66987

Thursday, March 03, 2011 10:02:30 AM

**PRELIMINARY
ISSUE**POSITIVE
RECALL

Page 1

Item ID: D4323-3

Accept

Revision ID: PRELIM

Item Name: N1 Access Cover, LH

Setup Start

Stop

Start Date: 3/3/2011 Start Qty: 1.00

Required Date: 3/11/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4323

PAT

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x1

Dh
11/03/01

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150° F

Time IN: 4:00 pm

Time OUT: 7:00 am

11/02/02

11/03/01

x1

Dh
11/03/01**PRELIMINARY ISSUE**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66987

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Page 2

Item ID: D4323-3

Accept

Setup Start

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Stop

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Start Date: 3/3/2011 Start Qty: 1.00

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg D4323-3 and Folio #FTAxxx using tool DT9711
Dwg Rev: PA3
Folio Rev: A

x1

JL.
11/03/01~~11/03/01~~ →

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

x1

JL.
11/03/01

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

-inspector to pay
Dwg only

8/10/01 (40)

W/O:		WORK ORDER CHANGES					
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11/03/14								

NOTE: Date & initial all entries

[illegible]

Page 3



Setup	Start	Stop
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364	365	366
367		



Abstract

Cust Item ID:[illegible]

Customer:

Reference:

Run	Start
	Stop

[illegible][illegible]

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 66987

Thursday, March 03, 2011 10:02:30 AM



Page 4

Item ID: D4323-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: N1 Access Cover, LH

Start Date: 3/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/3/08

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

~~11/3/08~~

RD2370

MF
11-03-08

POSITIVE RECALL

11-03-08 AUTH
DATE

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 10:02:35 AM

Page 1

Work Order ID: 66987

Parent Item: D4323-3

Parent Item Name: N1 Access Cover, LH



Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: New Issue 11-03-01 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	1,019.537	4.2	4.421053			



6185 KYDEX .080"



Location

therm

109703

116576

Loc Qty

1019.537564

81.189115

938.348449

Loc Code

4.2 sf

Sh.
11/03/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 66987
Description: Access cover LH	Part Number: D4323-3
Inspection Dwg: D4323 Rev: PA3.PAL	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <i>N/A</i>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <i>Dh</i>	Date: 11/03/04
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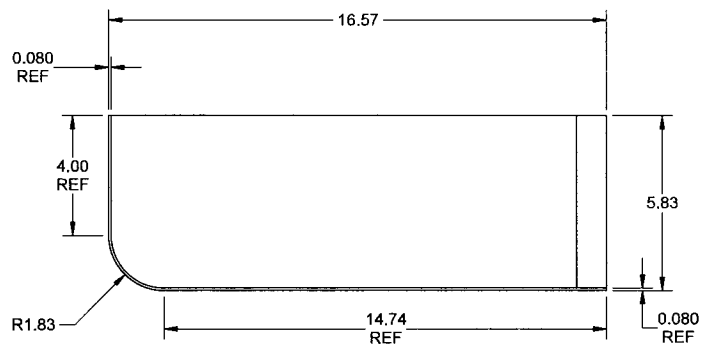
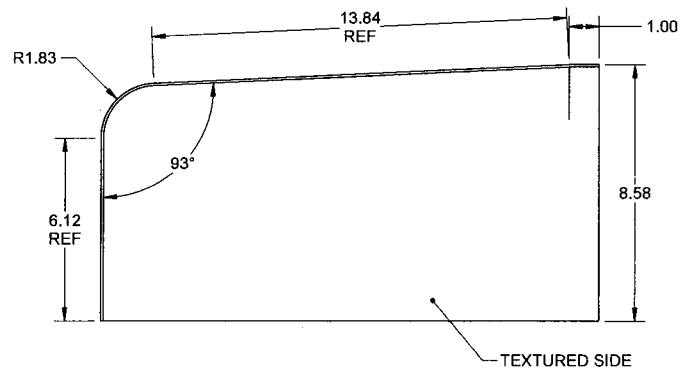
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.57"	$\pm 0.030"$	16.58"	✓			<i>Revised Tolerances for PA4. See attached Dh 11/03/07</i>
5.83"	$\pm 0.030"$	5.8"	✓			
8.58"	$\pm 0.030"$	8.5"				
93°	$\pm 1/2°$	93°				
0.080"	$\pm 0.030"$	0.074"				

Measured by: <i>Dh</i>	Date: 11/03/04
Audited by: <i>S to Part Dwg only</i>	Date: 11/03/07
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

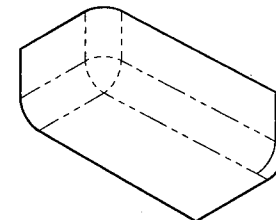
10-04-14



D4323-3 N1 ACCESS COVER, LH
D4323-4 N1 ACCESS COVER, RH (OPPOSITE)

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P1-HAIRCCELL, IVORY #62015
REF DART SPEC MKYD6185S.080-P1-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 33.81 lbs
- 8) TOOLING: THERMOFORM -3 PART PER MOLD DT9711, AND -4 PART PER MOLD DT9712. TRIM PER MOLD



SHOP COPY
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 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 66987

PL 11-03-3

**PRELIMINARY
 ISSUE**

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. PA3
MFG. APPR.		D4323	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	11.02.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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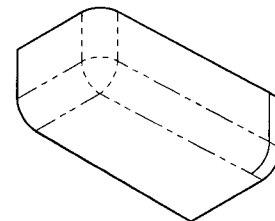
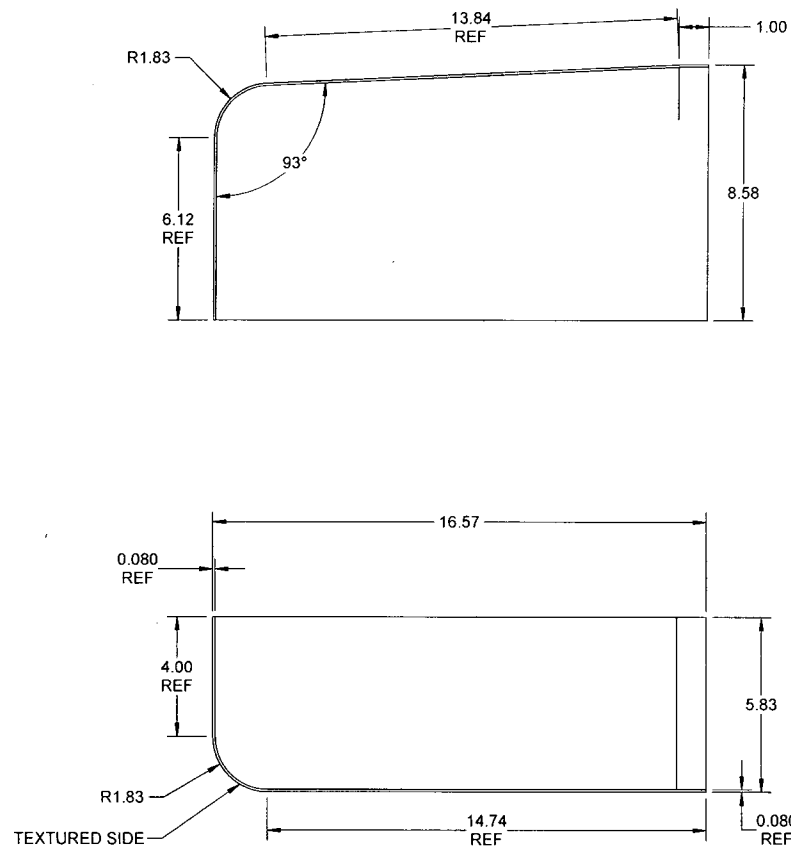
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



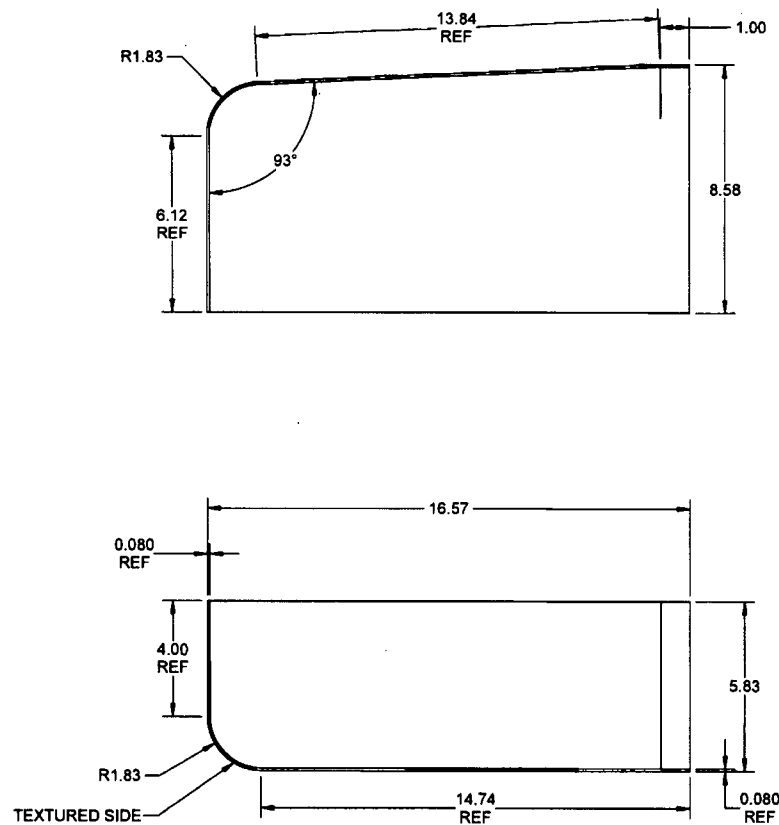
**PRELIMINARY
ISSUE**

**D4323-3 N1 ACCESS COVER, LH
D4323-4 N1 ACCESS COVER, RH (OPPOSITE)**

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 33.81 lbs
- 8) TOOLING: THERMOFORM -3 PART PER MOLD DT9711, AND -4 PART PER DT9712. TRIM PER MOLD
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

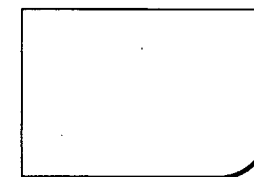
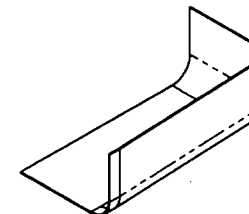
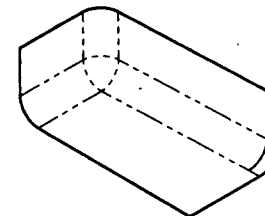
DESIGN		DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO. D4323	REV. PA4
MFG. APPR.			SHEET 3 OF 12
APPROVED		TITLE	SCALE
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D4323-3 N1 ACCESS COVER, LH
D4323-4 N1 ACCESS COVER, RH (OPPOSITE)

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 2.01 lbs
- 8) TOOLING: THERMOFORM -3 PART PER MOULD DT9711, AND -4 PART PER DT9712 AND PER DART QSI 022. TRIM PER MOULD
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040



DESIGN		DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D4323	REV. A
MFG. APPR.	SC	SHEET 3 OF 15	
APPROVED	SC	TITLE PANEL	SCALE NTS
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 2011-05-11
 MB

66987